



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18526-PO
Job Sheet 187403



Part No: RBT18526-PO

Job Qty: 1 ea

Part Name: Main Rotor Blade Bolt Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/15/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT18526 Rev. 1 IPP Rev. A 18.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		1/15/19	0.00	0.00	Purchasing		DEC 27 2018
110	Packaging	1 pcs		1/15/19	0.00	0.00	Packaging2		DEC 27 2018
120	QC	1 pcs		1/15/19	0.00	0.00	QC6		DEC 27 2018
140	QC	1 pcs		1/15/19	0.00	0.00	QC5	NOT REQUIRED	DEC 27 2018
150	Packaging	1 pcs		1/15/19	0.00	0.00	Packaging3		DEC 27 2018
160	QC21-FG	1 Ea		1/15/19	0.00	0.00	QC21		DEC 28 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 041932 MANUFACTURE RBT18526 AS PER DWG -
Descriptions: Certificate of conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18526P	Main Rotor Blade Bolt Extractor	1 Ea (1 ea)	100-Purchasing	5140308

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18526P	1	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 12/4/18 10:10 AM dart.Lussier.Patrick

Container No: S140309



Part: RBT18526

Job No: 187403

Serial No/Batch: S140309

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/27/18

DEC 3 1980

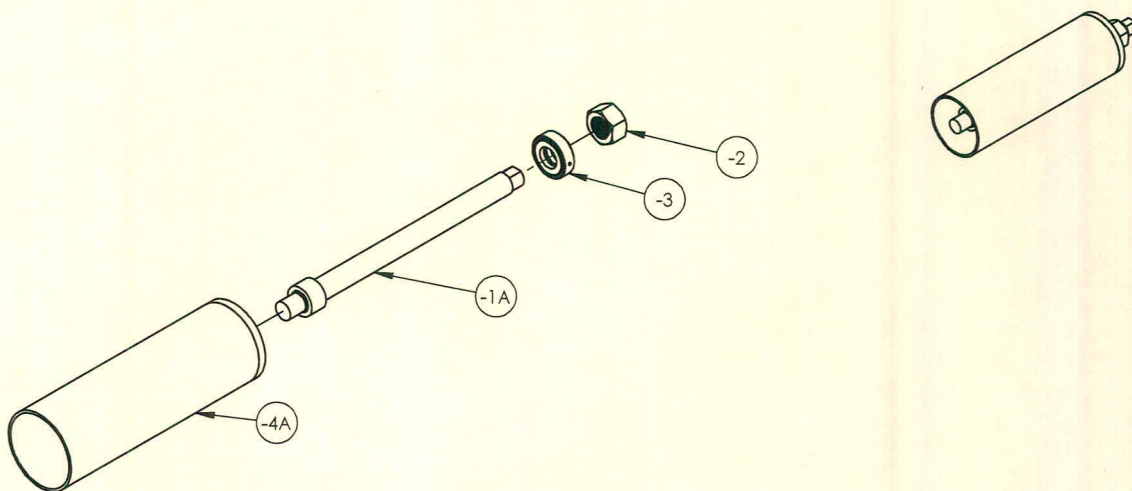
30
1980

70
1980

DEC 1 1980

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D TITLEBLOCK & REVISION BLOCK. MOVED WELDMENTS TO SEPARATE PAGE. LABELLED ASSY.. ADDED 1.00 DIM. AT END OF -1A. LABELLED AND CORRECTED SECTION A-A. ADDED ENGRAVE NOTE -5. ADDED END VIEW -5. MADE CORRECTIONS TO BOM.	12/29/2009	RJC	RW
1	15-0085	-1A ADDED NOTE  CH'D P/N WAS -6 IS -2. -3 ADDED P/N GRAINGER #42ZR3. -4 CH'D DIM WAS Ø1.970-1.969 IS Ø1.9530-1.9520. -6 DELETED.	5/12/2015	RJC	JAG

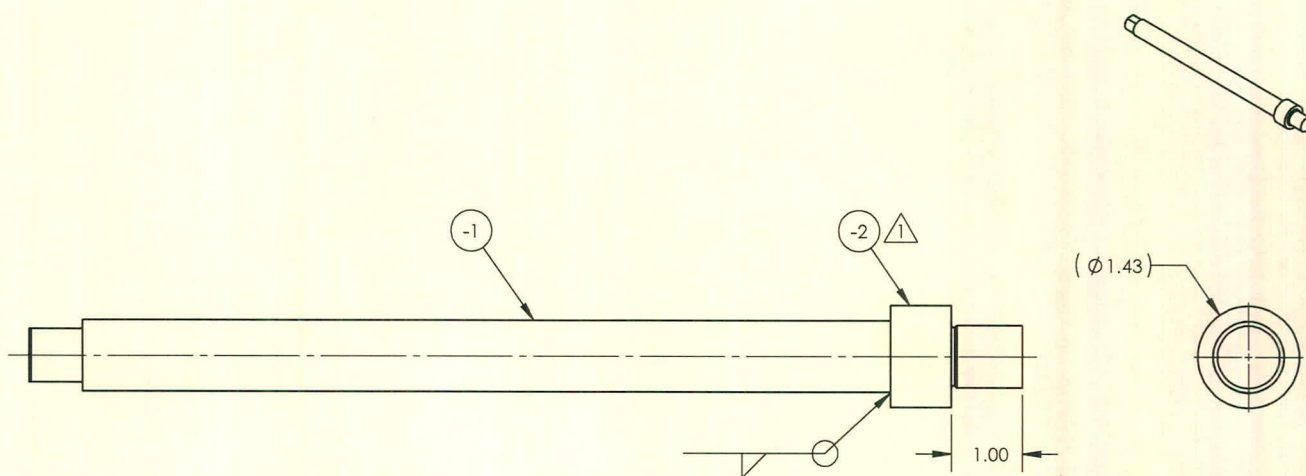


DART AEROSPACE	
TITLE M/R BLADE BOLT RETRACTOR	
DWG NO. RBT18526	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .016 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: COLE APPROVED <i>D. Mail</i> HEAT TREAT FINISH SPEC USED ON MODEL BELL 204, 205, 212
SCALE 1:6	DATE 3/14/2003 SHEET 1 OF 6

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	1	ROD WELDMENT			2
	1	B/O	-1		THREADED PULLER ROD	B7 ALL-THREAD	1-14 UNS (MCMASTER-CARR #92580A153) MODIFIED	3
	1	B/O	-2	1	HEX NUT	STEEL	1-14 UNS (MCMASTER-CARR #95505A621)	1
		B/O	-3	1	BANDED BALL THRUST BEARING	STEEL	Ø1 LD. X 1-31/32 X 5/8 (IDA #D9, GRAINGER #42ZR3 OR EQUIV.)	1
X			-4A	1	TUBE WELDMENT			4
1			-4		BEARING PLATE	1018/1020 CR		5
1			-5		TUBE	DOM		6
ASSY - 4A	ASSY - 1A							

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1	15-0085	-1A ADDED NOTE  , CH'D P/N WAS -6 IS -2.			5/12/2015	RJC	JAG



NOTE:

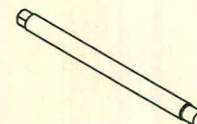
 AFTER WELDING MACHINE -2 NUT ROUND.

-1A
ROD WELDMENT

DART AEROSPACE	
TITLE M/R BLADE BOLT EXTRACTOR	
DWG NO. RBT18526-1A	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 6° .X ± .1	DRAWN BY: COLE APPROVED: <i>D. West</i> REWORK FINISH BLACK OXIDE SPEC
1. BREAK ALL SHARP EDGES .016 x 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BLL 204, 205, 212
SCALE 1:2	DATE 3/14/2003 SHEET 2 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



2X .03 X 45°

UNDERCUT
AS REQUIRED

2X R.03

1-14 UNS-2A

7/8-14 UNF -2A

.75

.75

1.00

Ø.90

14.0

THREADED PULLER ROD



TITLE
M/R BLADE BOLT EXTRACTOR

DWG NO. RBT18526-1

REV
1

MAT'L B7 ALL-THREAD

DRAWN BY: COLE

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

APPROVED *D. West*

.XXX ± .005 FRACTIONS ± 1/8

REMARKS

.XX ± .01 ANGLES ± 6°

TREAT

.X ± .1

FINISH SEE -1A WELDMENT

1. BREAK ALL SHARP EDGES .015 X 45°

SPEC

OR .015R

USED ON MODEL

2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

BELL 204, 205, 212

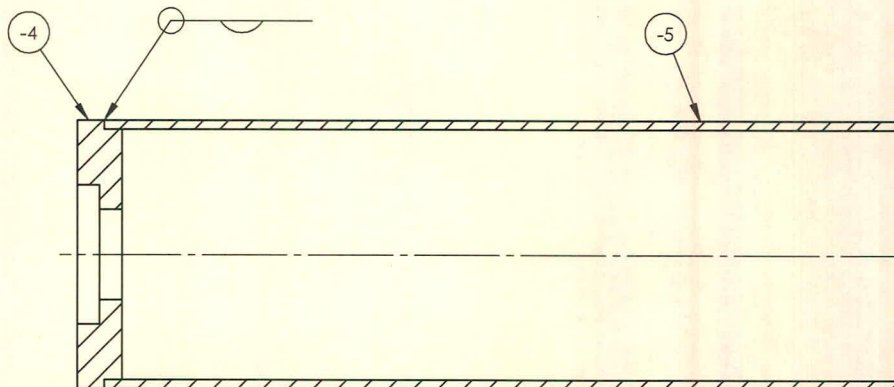
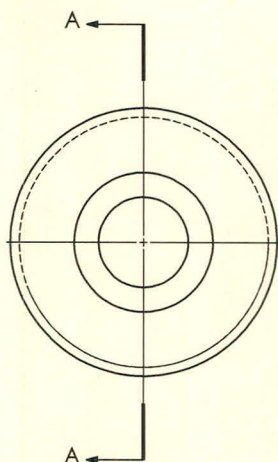
SCALE 1:2

DATE 3/14/2003

SHEET 3 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

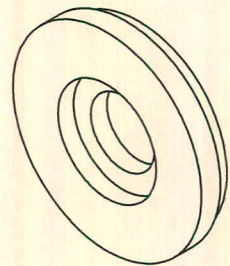
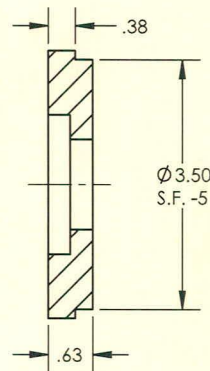
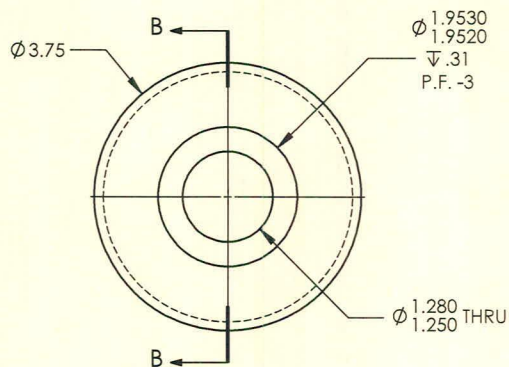
-4A

TUBE WELDMENT

DART AEROSPACE	
TITLE M/R BLADE BOLT EXTRACTOR	
DWG NO. RBT18526-4A	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: COLE APPROVED: <i>D. Weir</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL BELL 204, 205, 212
SCALE 1:2	DATE 3/14/2003
SHEET 4 OF 6	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1	15-0085	-4 CH'D DIM WAS Ø1.970-1.969 IS Ø1.9530 -1.9520.	5/12/2015	RJC
				JAG



SECTION B-B

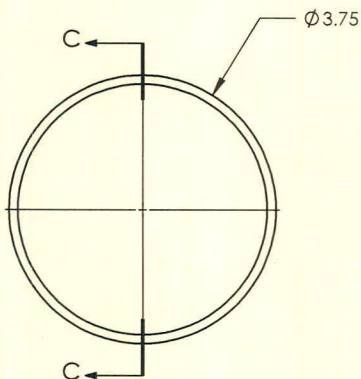
(-4)

BEARING PLATE

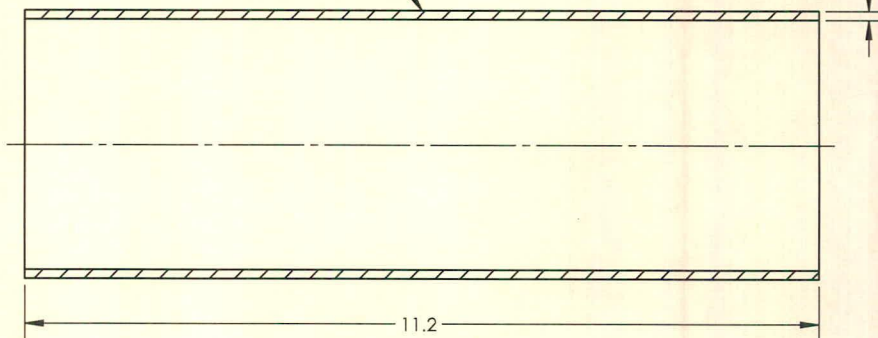
DART AEROSPACE	
TITLE M/R BLADE BOLT EXTRACTOR	
DWG NO. RBT18526-4	REV 1
MAT'L 1018/1020 CR	DRAWN BY: COLE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. West</i>
.XXX ± .005 FRACTIONS ± 1/8	REPT
.XX ± .01 ANGLES ± .6°	FINISH SEE -4A WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204, 205, 212
SCALE 1:2	DATE 3/14/2003
	SHEET 5 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



ENGRAVE T/N, S/N,
MADE IN USA



SECTION C-C

(-5)

TUBE

DART AEROSPACE	
TITLE M/R BLADE BOLT EXTRACTOR	
DWG NO. RBT18526-5	REV 1
MAT'L DOM UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: COLE
.XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D. Mail</i>
FRACTIONS ± 1/8 ANGLES ± 5°	HEAT TREAT FINISH SEE -4A WELDMENT
1. BREAK ALL SHARP EDGES .016 x 45° OR .016R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 204, 205, 212
SCALE 1:2	DATE 3/14/2003
SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041932**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041932
PO Date: 12/4/18
Due Date: 1/15/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	187403	RBT18526P			Main Rotor Blade Bolt Extractor REV 1	Firmed	-	1/15/19	1 Ea	0 Ea	1 Ea	\$813.00/Ea	\$813.00
Line Item Note To Replace unit from PO040860													
Grand Total:												\$813.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 12/4/18 10:24 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 372

Date: 12/21/2018
PO Ref: 041932 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

1 ✓

Item

MAIN ROTOR BLADE BOLT EXTRACTOR

Part No.

RBT18526 ✓

Received by: _____

Packaged by: _____

Checked by: MS.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041932 ✓

Dated: 12/21/2018

Our Order / Job No: 041932-1AWT

Order Qty: 1 ✓

Part Name: M/R BLADE BOLT EXTRACTOR

Part Number: RBT18526 ✓

Lot Size: N/A

Ship Date: 12/21/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBT18526

Rev: 1

Material Size and Type: -4/1018 STEEL; -5/ DOM STEEL

Material Specifications: 1018 STEEL: ASTM A108, ASTM A29; DOM STEEL: ASTM A513

Heat Treatment: N/A

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/21/18

Signed: 

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

